

A / . 150

Work Order ID 74877

October 13, 2011 10:41:27 AM

74877

Page 1

Item ID: D3490-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cross Bolt Spacer

Stop

NS2

Start Date: 10/13/11 Start Qty: 40.00

40

Cust Item ID:

Required Date: 10/27/11 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: M L JDate: 11/10/14 Tooling: _____ Date: _____

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3490	Rev A	

100 0.00

100 Hardinge CNC LATHE SMALL

Hardinge Memo 0.00

Hardinge CNC Lathe Small 1-TURN AS PER FOLIO FA629 & DWG D3490

FOLIO REV: A DWG REV: A

2-DEBURR AS REQUIRED

40 0 11/10/23

110 0.00

110 QC2- Inspect parts off machine FAI/FAIB

Quality Control Memo 0.00

40 0 11/10/23

120 0.00

120 QC QC8- Inspect parts - second check

Quality Control Memo 0.00

40 0 _____

120 0.00

120 QC QC8- Inspect parts - second check

Quality Control Memo 0.00

120 0.00

120 QC QC8- Inspect parts - second check

Quality Control Memo 0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74877

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Item ID: D3490-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cross Bolt Spacer

Stop

NS2

Start Date: 10/13/11 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 10/27/11 **Req'd Qty:** 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

130

Identify as per dwg & Stock Location: LG

130

Packaging

Packaging

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

*40 0
BE 4
BE 11/10/29*

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

11/10/29

*MT
11-10-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

October 13, 2011 10:41:32 AM

Page 1

Work Order ID: 74877

74877

Parent Item: D3490-3

D3490-3

Parent Item Name: Cross Bolt Spacer

Start Date: 10/13/11

Required Date: 10/27/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	6.1780	0.266	11.2	**	10.700	11/10/23

M6061T6R0 750

6061-T6 Round Bar .750"

Location	Loc Qty	Loc Code
MAT013	6.178	
112442	0.796	
116406	0.617	
117481	2.51	
118106	2.255	

11/10/23

10.700

11.5 ft

1.166 ft

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74877
Description: Crossbolt Spacer	Part Number:	D3490-3
Inspection Dwg: D3490	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>D. J. S.</u>	Audited by:	<u>D. P.</u>	Prototype Approval:	N/A
Date:	<u>11/10/21</u>	Date:	<u>11.10.23</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.27	New Issue	KJ/JLM	SJM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

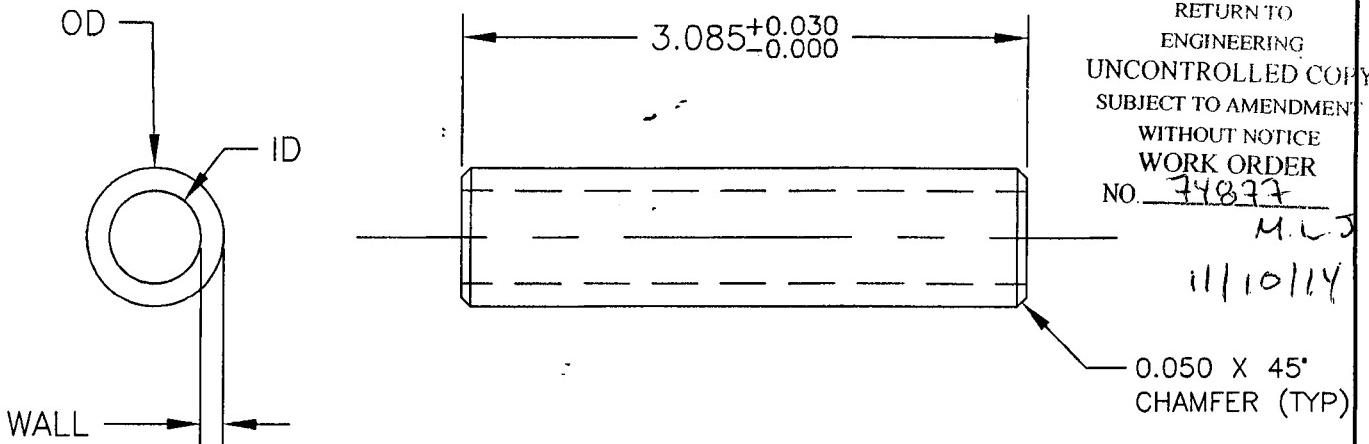
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3490	REV. A	SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS	
A	06.01.04	NEW ISSUE		

D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
do-02-07

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